

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011867**Date Inspected:** 19-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing(MPT)

This Quality Insurance Inspector (QA) performed 100% verification Magnetic Particle Testing (MT) for OBG segment 5AE, Deck Panel Diaphragm to U-rib welds area. This weld was previously 10% tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

DP-459-001-100,101,103,105,106,108,111,110,113,114,116,119,118,121,122,124,126,127,129,130,132,135,134,137,135,138,140

DP-486-001-062,063,065,067,068,070,072,073,075,076,078,080,081,083,084,086

DP-324-002-081,082,084,086,087,089,092,091,094,095,097,100,099,102,103,105,107,108,110,111,113

DP-378-100,101,103,105,106,108,111,110,113,114,116,119,118,121,122,124,126,127,129,130,132,135,134,137,135,138,140

DP-405-001-100,101,103,105,106,108,111,110,113,114,116,119,118,121,122,124,126,127,129,130,132,135,134,137,135,138,140

DP-432-001-100,101,103,105,106,108,111,110,113,114,116,119,118,121,122,124,126,127,129,130,132,135,134,137,135,138,140

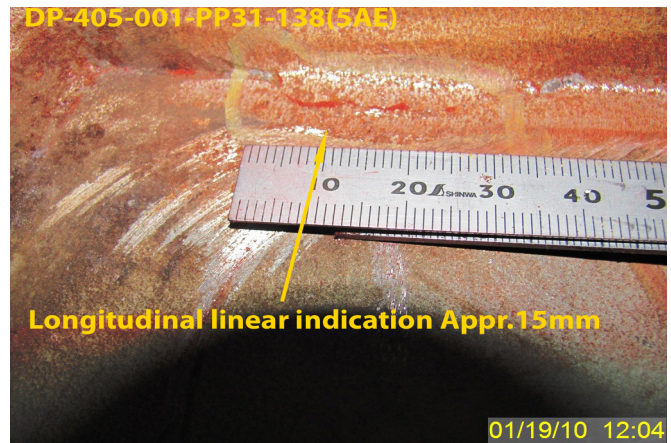
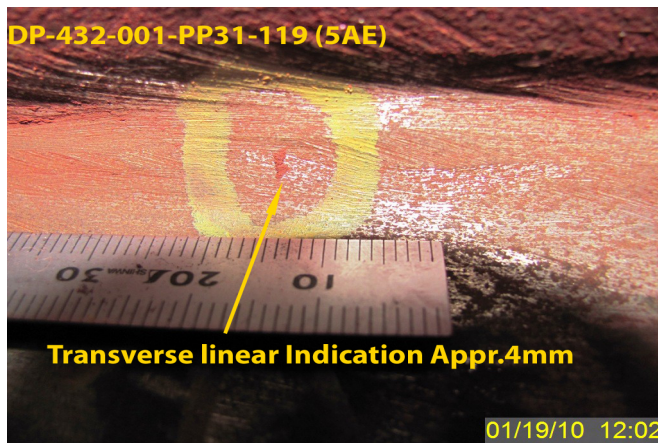
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DP-297-001-062,063,065,067,068,070,072,073,075,076,078,080,081,083,084,086
DP-351-001-100,101,103,105,106,108,111,110,113,114,116,119,118,121,122,124,126,127,129,130,132,135,134,
137,135,138,140
DP-324-002-081,082,084,086,087,089,092,091,094,095,097,100,099,102,103,105,107,108,110,111,113
DP-297-001-007,008,010,013,014,016,018,019,021,022,023,025,027,028,031,032,034
DP-324-001-009,010,012,015,016,018,029,021,024,025,027,029,030,033,034,035,038,039,042,043,045
DP-351-001-011,012,014,017,018,020,022,023,026,027,029,031,032,035,036,038,040,041,044,045,047,049,050,
053,054,056
DP-378-001-
011,012,014,017,018,020,022,023,026,027,029,031,032,035,036,038,040,041,044,045,047,049,050,053,054,056

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 5AE, this Quality Assurance Inspector (QA) discovered that One (1) Longitudinal linear indication measuring approximately 15mm in length and One (1) transverse linear indication measuring approximately 4mm in length at the Panel Point PP31. The indication is clearly marked on the material near the weld. The welds are identified as DP-432-001-119 and DP-405-001-138. This welds are fillet Weld joining the Deck plate Diaphragm to U-rib. See the attached photo for reference.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera,Subhasis

Quality Assurance Inspector

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Reviewed By: Patterson,Rodney

QA Reviewer